

Work Order ID 82955

82955

Page 1

Wednesday, April 11, 2012 3:08:15 PM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 4/11/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2750 | F |
| D3492 | C |

X SP

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

Set

1 12-06-25
for MCT 12-6-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

110

Skidtubes

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D2750 ✓3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr. ✓4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade
fitting ✓

5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) ✓7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ✓
SECOND SIDE8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail L to 0.500" (8 holes per side) ✓9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297". ✓

10-Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓

JAB 12-04-12

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch: *M120854*

12-Grind welds flush as per Dwg D2750

*SAD**BE 12/04/19*
12-04-19

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

S. 7/14/20

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

S. 7/14/20

Quality Control

8

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

7/6 12-4-23

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

1 D B612-04-23

Dart Aerospace Ltd

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Stop ***NS2***

Item Name: Skidtube RH

Start Date: 4/11/2012 Start Qty: ~~1~~ 1.00***1***

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2- Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3- Open float holes to .500" (4 per Side)

4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5- Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7- Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: m121221
exp. date: 13-1-4

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R Aluminum Rod batch: m120854

9- At section AP-AP drill out x-bolt spacer to 0.404"

10- Grind welds flush as per Dwg D2750

11- Spot face ground handling holes section (total of 4 places per side) as per

1 ~~0~~ CF 12-4-23

CF 12-4-25

308612-04-26

SPD/CF 12-5-1

Dart Aerospace Ltd

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Stop ***NS2***

Item Name: Skidtube RH

Start Date: 4/11/2012 Start Qty: 1.00

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Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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N900040100Setup Start ***NS1***

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Stop ***NS2***

Item Name: Skidtube RH

Start Date: 4/11/2012 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

NG 12-5-2

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:20
320 °F
3:50IX ✓ M-F
12/5/02

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

IR+1 q HL ulos
10/10/02

Dart Aerospace Ltd

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Required Date: 4/26/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230 | HandFinishing | 0.00 | | | | | | | |
| *230* | HandFinish | 0.00 | | | | | | | |
| Hand Finishing | Memo 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Spray inside of tube with "LPS-3" batch: <u>NIA</u> 4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>11121221</u> EXP DATE: <u>13101</u> 5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>11110348</u> 6-Coat all exposed fasteners with "LPS Procyon" batch: <u>11114596</u> | | | | | | | | |

IRH ϕ M 11/05/12
Pto \rightarrow

| W/O: 82955 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: D350-636-012 PAR #: _____ Fault Category: Skid tube NCR: Yes No DQA: Y Date: 12/06/08
 Resolution: _____ Disposition: Rework QA: N/C Closed: C Date: 12/16/29

| NCR: 12-1538 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|--------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|---------------------------------------------------------------------------------------------------------------|---------------------|---------------------------|-----------------------|--------------------------|
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| 12/06/03 | # 230 | Found the Damin Assembly that D3488-041/042 Doesn't Align w/te skid tube. R.C. tol. on D3488-041/042 AND Hummman Drilling of skid | GP 12-06-04 | Drill out 24 x 5 Aft most Holes to max tol. on skid tube Drill out 24 x 5 holes on D3488 to max tol. | 12-6-06 12-06-04 | 12/06/08 | GP 12-06-04 | 12/06/03 |
| | | Process | GP 12-06-04 | touch up Align as per 042005 AND Re-assembly | 12-6-18 | 12/06/08 | GP 12-06-04 | 12/06/03 |
| | | | | | | | | |

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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Run Start ***NR1***

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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

Rev F

IX
SP
12-6-26

280

0.00

280

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/6/27
MF
12-06-26

Dart Aerospace Ltd

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2600-3-BENT

Manufactured No

110

Each

24.0000

1

D2600-3-BFNT

Extrusion Bent

B83305

**

① 808: 12-04-19

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 24 | |
| 66875 | 7 | |
| 73253 | 1 | |
| 75021 | 1 | |
| 75022 | 1 | |
| 75023 | 1 | |
| 81330 | 4 | |
| 82347 | 9 | |

D2744

Manufactured No

110

Each

39.0000

1

D2744

Cap

**

BE 12/04/19

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG002 | 39 | |
| 62715 | 1 | |
| 70881 | 3 | |
| 78900 | 35 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

5.0000

1

1

D2739

350 I Beam

**

①

CF 12.4.25

B83449

Location

Loc Qty

Loc Code

LG

5

72155

1

81508

1

82123

3

D2743

Manufactured No

160

Each

290.0000

8

8

D2743

Crossbolt Spacer

**

BE 12-04-25

Location

Loc Qty

Loc Code

LG

-3

81965

207

LG001

293

67766

4

68251

3

73403

64

74445

1

78603

2

79517

9

D3490-3

Manufactured No

160

Each

58.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE 12-04-26

Location

Loc Qty

Loc Code

LG

56

82016

56

LG001

2

78800

2

Wednesday, April 11, 2012 3:08:20 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 3

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No 160 Each 92.0000 4 4

D3490-1

Cross Bolt Spacer

**

RF 12-04-26

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| LG | 83 | |
| 81976 | 83 | |
| LG001 | 9 | |
| 62450 | 2 | |
| 74875 | 4 | |
| 77042 | 3 | |

D3631-1 Manufactured No 230 Each 227.0000 8 8

D3631-1

Washer

**

yl 12105103

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FG | 100 | |
| 81874 | 100 | |
| ST072 | 127 | |
| 68062 | 2 | |
| 75548 | 125 | |

D3791-1 Manufactured No 230 Each 25.0000 1 1

D3791-1

Wearplate

**

yl 12105103

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 25 | |
| 62239 | 2 | |
| 78897 | 7 | |
| 82168 | 16 | |

B83392

x1

Wednesday, April 11, 2012 3:08:20 PM

Shop Packet Print

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

30.0000

1

1

D3793-3

Wearshoe

**

Y1 12/05/03

Location

Loc Qty

Loc Code

FP001

23

80434

11

82166

12

FP002

7

78935

7

MS21043-6

Purchased No

230

Each

765.0000

4

4

MS21043-6

NUT

**

Y1 12/05/03

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

745

112314

39

117887

6

118384

200

120308

500

D3794-1

Manufactured No

230

Each

39.0000

1

1

D3794-1

Gasket

**

Y1 12/05/03

Location

Loc Qty

Loc Code

FP

23

82167

23

FP002

16

75042

4

80435

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

259.0000

8

8

NAS1611-010

O-RING

**

41 12/05/03

Location

Loc Qty

Loc Code

FP

50

11121415

28

110915

0

120770

50

FP001

209

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

36

121259

50

D2741

Manufactured

No

250

Each

61.0000

1

1

D2741

Blade, 350 Skidtube

**

SP 12-6-22

Location

Loc Qty

Loc Code

ST

-10

ST466

71

71856

1

76984

20

79516

40

1x

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

190.0000

4

4

***NAS1515H3I ***

WASHER

**

yl 11/05/10 3

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

150

118686

3

119438

1

120360

96

121243

50

X4

NAS1611-013

Purchased

No

230

Each

218.0000

8

8

NAS1611-013

O-RING

**

yl 11/05/10 3

Location

Loc Qty

Loc Code

FP001

218

116582

5

117291

2

117887

53

119623

36

120910

4

121166

68

121259

50

NA 121584

X9

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 501.0000 4 4

AN3C6A

BOLT

**

HL 12/05/03

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 1 | |
| 111982 | 1 | |
| ST351 | 500 | |
| 111982 | 2 | |
| 116419 | 23 | |
| 116549 | 2 | |
| 116704 | 12 | |
| 117619 | 10 | |
| 117688 | 1 | |
| 117872 | 5 | |
| 118422 | 13 | |
| 119449 | 21 | |
| 120423 | 11 | |
| 120693 | 400 | |

XL

NAS1149C0832R Purchased No 230 Each 293.0000 1 1

NAS1149C0832R

WASHER

**

HL 12/05/03

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST297 | 293 | |
| 114915 | 293 | |

XL

D3536-25 Manufactured No 230 Each 22.0000 1 1

D3536-25

Gasket

**

HL 12/05/03

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP | 14 | |
| 81342 | 14 | |
| FP002 | 8 | |
| 78902 | 8 | |

1383391

Y1

Wednesday, April 11, 2012 3:08:20 PM

Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3 Manufactured No

230 Each 23.0000 1 1

D3794-3

Gasket

**

HL 12/05/03

Location

Loc Qty

Loc Code

FP002

23

B83396

VI

74530

2

80436

21

AN3C5A Purchased No

230 Each 1,592.000 34 34

AN3C5A

Bolt

**

HL 12/05/03

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1585

X1121060

X31

116419

28

117343

13

117764

7

117872

2

119749

23

120423

512

1210168

500

121255

500

D3537-1 Manufactured No

230 Each 69.0000 3 3

D3537-1

Wearpad

**

HL 12/05/03

Location

Loc Qty

Loc Code

FG

10

B81959

X3

79833

10

FP002

59

69817

5

80337

5

81361

49

Wednesday, April 11, 2012 3:08:20 PM

Shop Packet Print

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25 Manufactured No

230 Each 39.0000 1 1

D3535-25

Wearshoe

**

21 12/05/03

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP001 | 39 | |
| 62233 | 1 | |
| 80331 | 10 | |
| 81357 | 11 | |
| 82156 | 17 | |

D3492-3 Manufactured No

230 Each 69.0000 8 8

D3492-3

Plug

**

B83099 (x8) 21 12/05/02

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP-A | 69 | |
| 81967 | 69 | |

AN960C10L NAS1149C0332 Purchased No

230 Each 0.0000 38 38

***AN960C10I *** ✓

washer

**

(x38) 21 12/05/02

D3488-042 Manufactured No

230 Each 15.0000 1 1

D3488-042

Blade Fitting Assembly, RH

**

21 12/05/03

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP002 | 15 | |
| 62003 | 1 | |
| 75068 | 8 | |
| 77015 | 6 | |

B82258

21

Wednesday, April 11, 2012 3:08:20 PM

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

2,433.000

38

38

AI S4-1032-225

Insert

**

12105103

Location

Loc Qty

Loc Code

ST281

2410

108696

146

110768

62

118386

55

118966

68

120671

79

121269

2000

ST282

23

120410

10

120451

13

x38

D3492-1

Manufactured

No

230

Each

30.0000

8

8

D3492-1

Plug

**

12105103

Location

Loc Qty

Loc Code

FP002

30

69531

8

74444

2

76235

4

77037

16

1383098

x8

D3793-1

Manufactured

No

230

Each

26.0000

1

1

D3793-1

Wearshoe

**

12105103

Location

Loc Qty

Loc Code

FP001

26

78901

10

82171

16

x1

Wednesday, April 11, 2012 3:08:20 PM

Shop Packet Print

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 11

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

104.0000

1

1

AN8C35A

BOLT

**

xl n105103

Location

Loc Qty

Loc Code

FP002

103

115960

1

117834

7

118286

45

121275

50

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

105.0000

1

1

MS21083C8

NUT

**

xl n105103

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

49

120142

7

120731

17

121011

25

Wednesday, April 11, 2012 3:08:20 PM

Shop Packet Print

Page 11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 12

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

48.0000

8

8

D2745

Bushing

**

ysl 12/05/03

Location

Loc Qty

Loc Code

FP

46

79518

46

FP001

2

B81964

x8

69529

1

76142

1

AN6C44A

Purchased No

230

Each

170.0000

4

4

AN6C44A

BOLT

**

ysl 12/05/03

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

168

120143

25

120465

23

121013

20

121167

100

x4

D3532-1

Manufactured No

250

Each

51.0000

2

2

D3532-1

Spacer

**

SP 12-6-22-

Location

Loc Qty

Loc Code

ST053

51

78839

27

82041

24

2x

Wednesday, April 11, 2012 3:08:20 PM

Shop Packet Print

Page 12

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

105.0000

2

2

MS21083C8

NUT

**

M12/1349 2x
SP

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

5

115884

0

118077

1

119309

2

119638

2

ST304

49

120142

7

120731

17

121011

25

NAS1149D0863J

Purchased

No

250

Each

211.0000

2

2

NAS1149D0863J

WASHER

**

SP 12-6-22

Location

Loc Qty

Loc Code

ST298

211

118078

36

119307

75

120308

100

2x

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 14

Wednesday, April 11, 2012 3:08:20 PM

Work Order ID: 82955

82955

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 4/11/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

87.0000

2

2

D3493-1

Washer

**

SP

Location

Loc Qty

Loc Code

ST050

87

70697

2

77573

4

78835

40

82023

41

2x

AN8C21A

Purchased

No

250

Each

121.0000

2

2

AN8C21A

BOLT

**

SP 12-6-22.

Location

Loc Qty

Loc Code

ST343

121

118758

5

120094

26

121067

20

121167

20

121275

50

2x

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

| QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|-------------|-------------|-------------|-------------|---------------|---------------------------------------------------------|
| X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| | X | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| | | X | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | X | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| 1 | 1 | 1 | 1 | D2739 | WEB |
| 8 | 8 | 8 | 8 | D2743 | SPACER |
| 1 | 1 | 1 | 1 | D2744 | CAP |
| 8 | 8 | 8 | 8 | D2745 | BUSHING |
| 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| 4 | 4 | | | D3490-3 | SPACER |
| | | 4 | 4 | D3490-5 | SPACER |
| 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL Δ
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL Δ

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82955
PL 12-04-11

RELEASED
6-27-22

| | | | |
|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|
| F | INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A5-1); REASON: REF. NCR 08-043 | PH | 08.07.16 |
| E | CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8 | CB | 07.05.17 |
| D | ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157 | PH | 06.01.05 |
| C | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740 | CP | 98.11.18 |
| B | CHANGE MS24694-S293 TO AN8-16A | CP | 98.09.01 |
| A | NEW ISSUE | DS | 98.04.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PORT HADLOCK, WA | DART AEROSPACE USA, INC. | |
| DRAWN | | DRAWING NO. | REV. F |
| CHECKED | | D2750 | SHEET 1 OF 11 |
| MFG. APPR. | | TITLE | SCALE |
| APPROVED | | 350 SKIDTUBE ASSEMBLY | NTS |
| DE APPR. | | COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. | |
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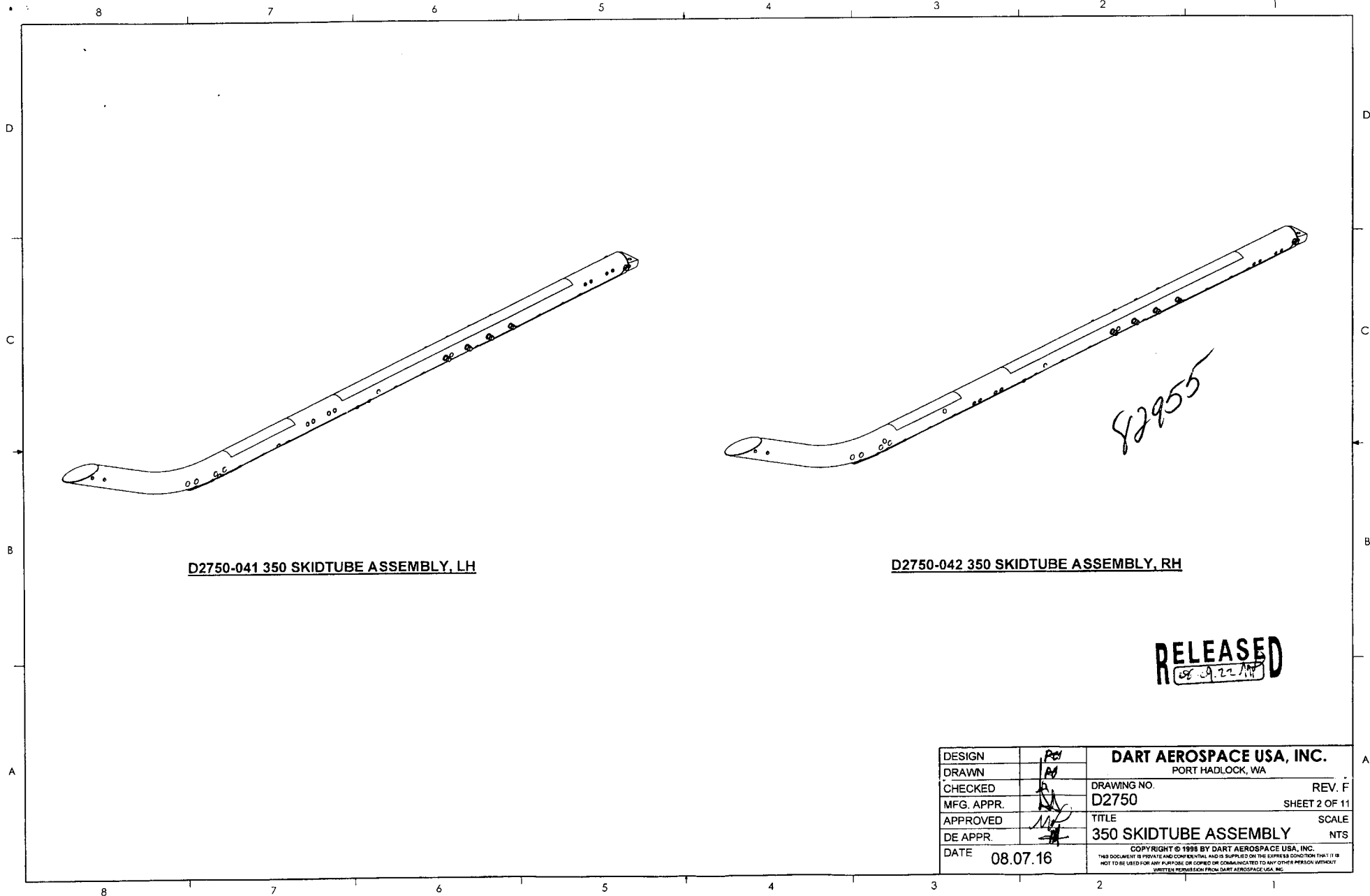
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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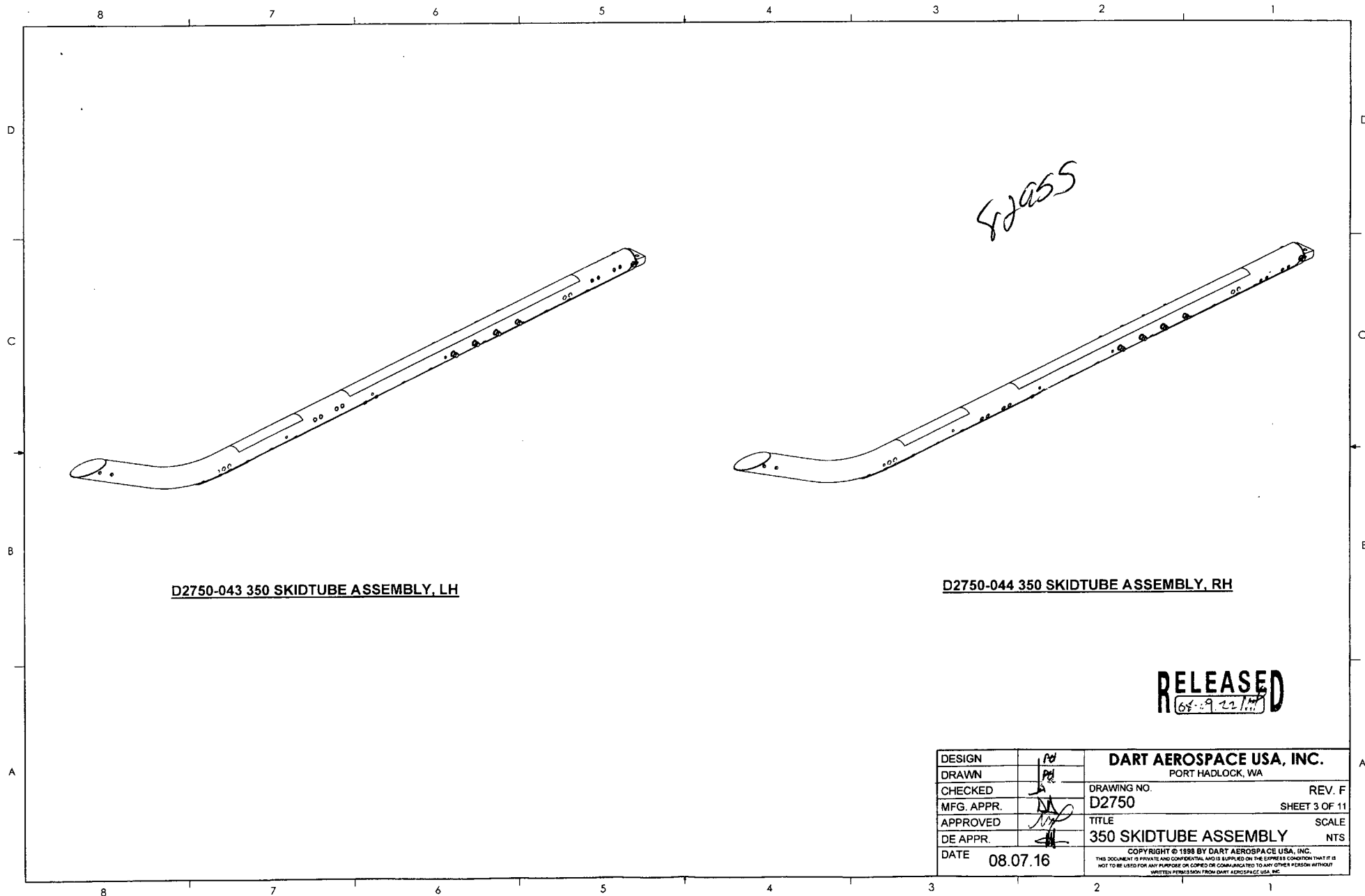
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries



D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08-09-22/11

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|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------|
| DESIGN | 10 | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWN | 10 | | |
| CHECKED | 10 | DRAWING NO. D2750 | REV. F |
| MFG. APPR. | 10 | SHEET 3 OF 11 | |
| APPROVED | 10 | TITLE 350 SKIDTUBE ASSEMBLY | SCALE NTS |
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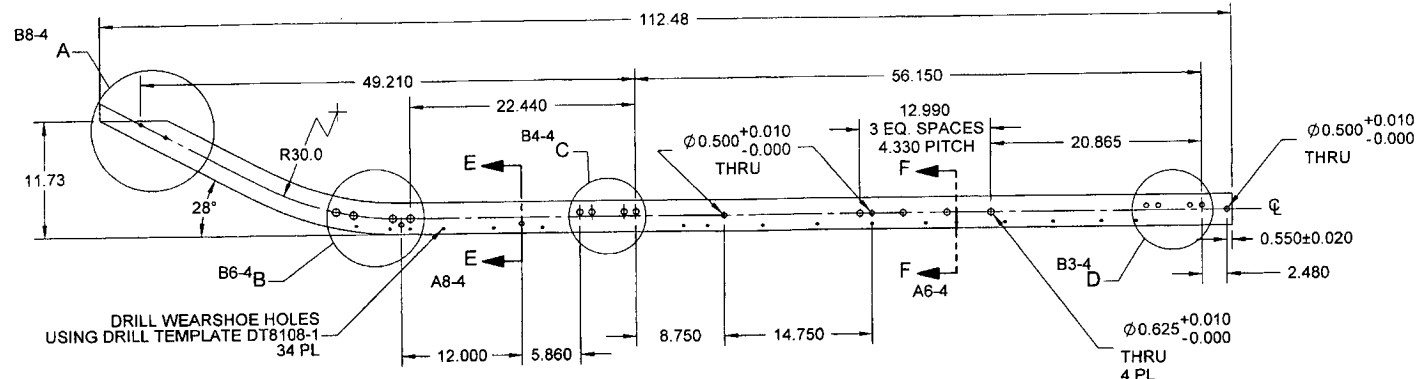
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

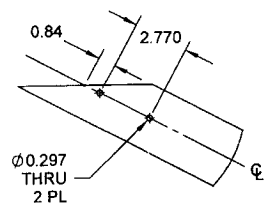
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NOTE: Date & initial all entries

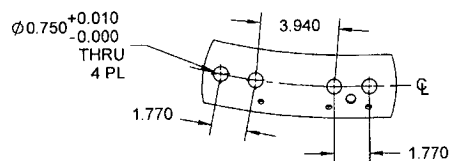


D2750-1 LH SKIDTUBE

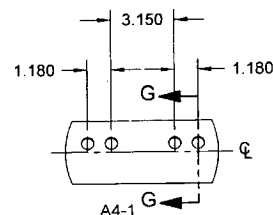
82955



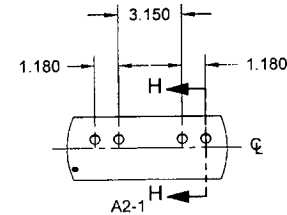
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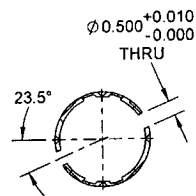
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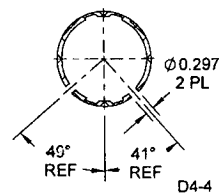
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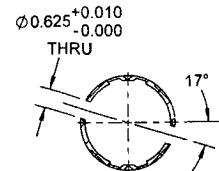
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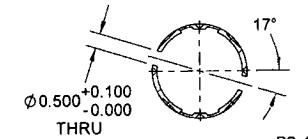
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SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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| DESIGN | PA | DART AEROSPACE USA, INC. | |
| DRAWN | PA | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2750 | SHEET 4 OF 11 |
| APPROVED | | TITLE | SCALE |
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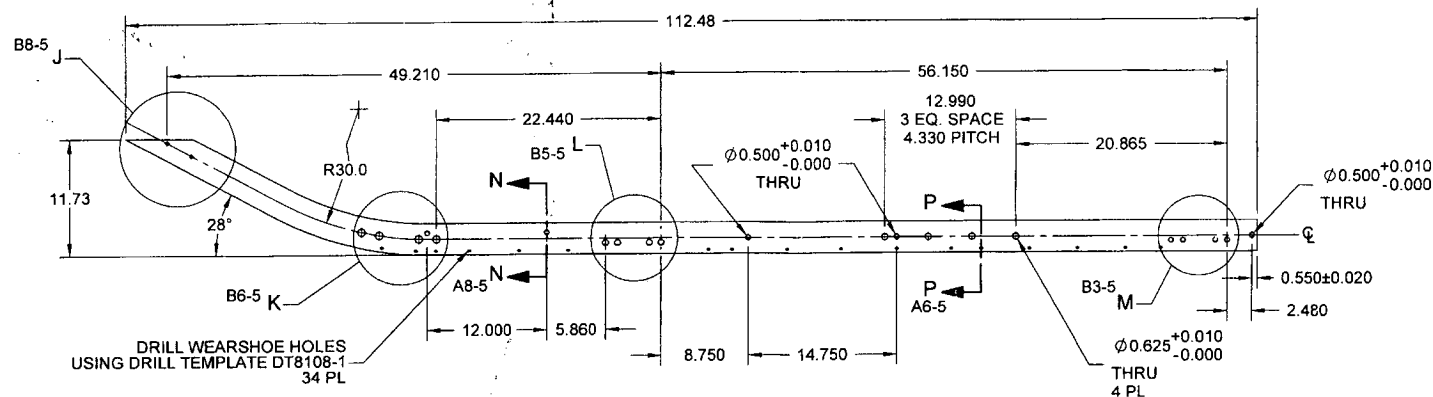
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

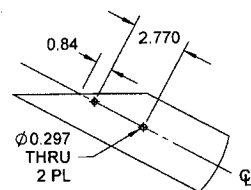
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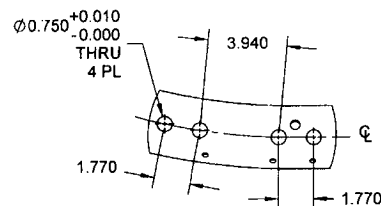
NOTE: Date & initial all entries



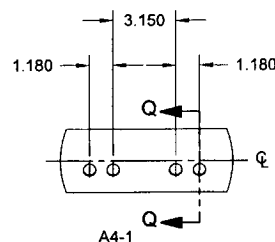
D2750-2 RH SKIDTUBE



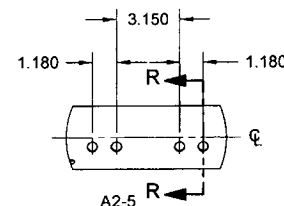
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SCALE 2X



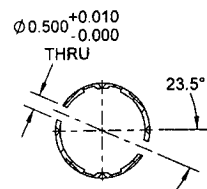
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SCALE 2X



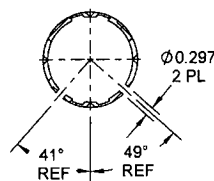
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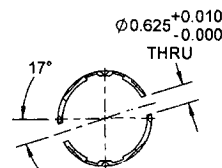
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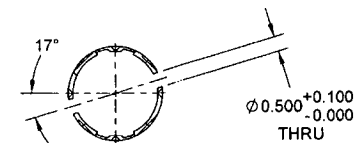
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

| | | | |
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| DRAWN | REV | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2750 | SHEET 5 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
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82955

(F)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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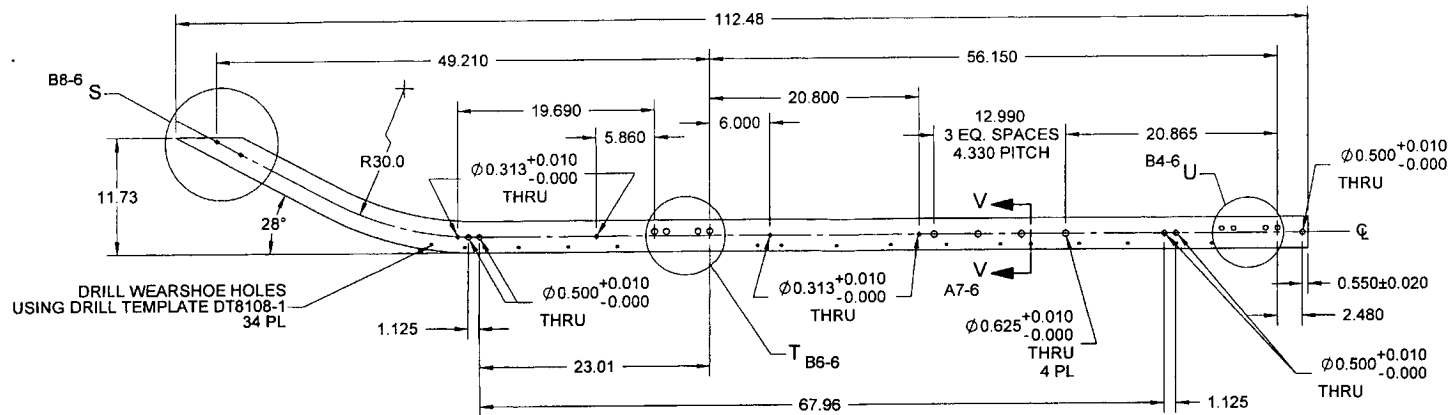
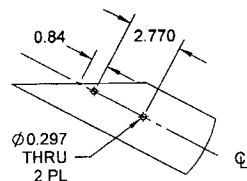
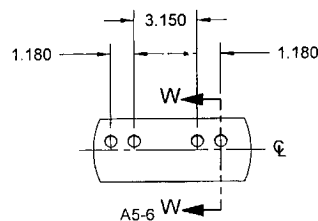
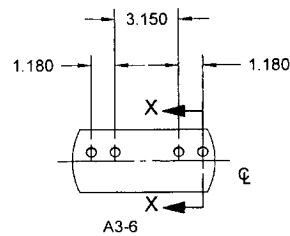
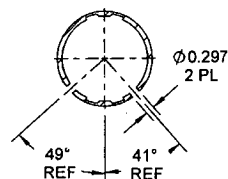
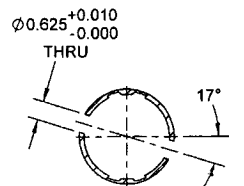
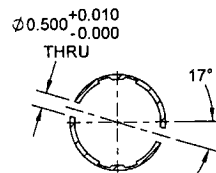
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**D2750-3 LH SKIDTUBE****DETAIL S**
SCALE 2X**DETAIL T**
SCALE 2X**DETAIL U**
SCALE 2X**SECTION V-V**
SCALE 3X, 17 PL**SECTION W-W**
SCALE 3X, 4 PL**SECTION X-X**
SCALE 3X, 4 PL

82955

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08 07 16

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| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2750 | SHEET 6 OF 11 |
| APPROVED | | TITLE | SCALE |
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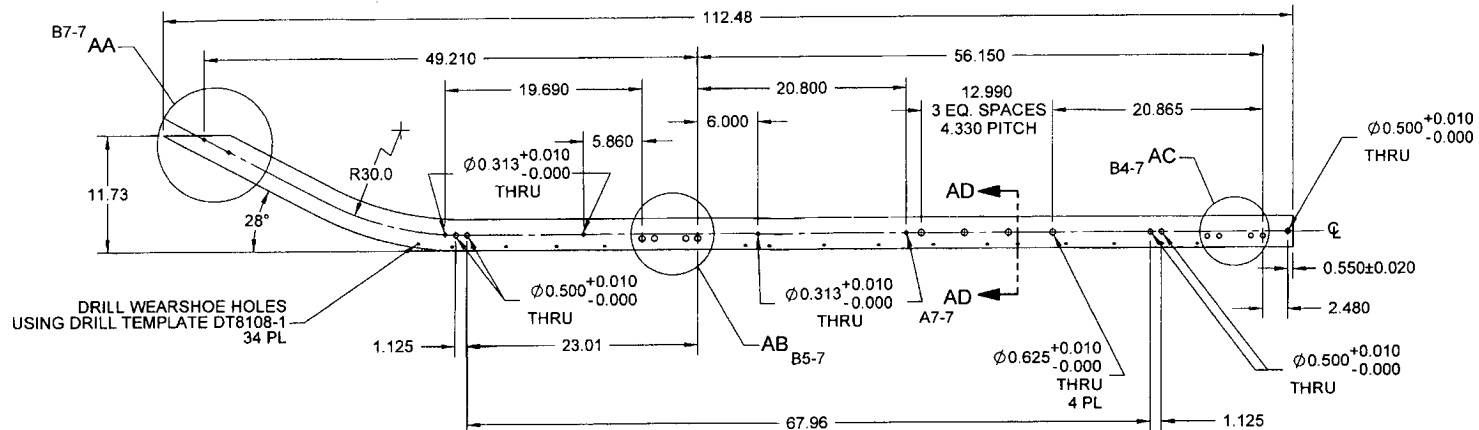
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

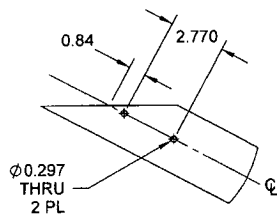
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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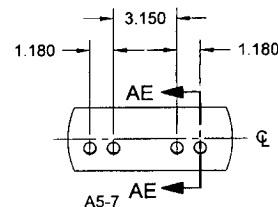
NOTE: Date & initial all entries



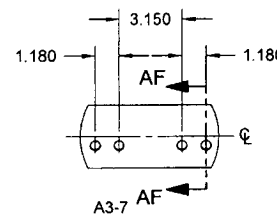
D2750-4 RH SKIDTUBE



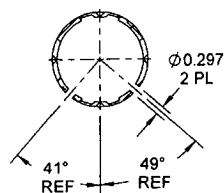
DETAIL AA
SCALE 2X



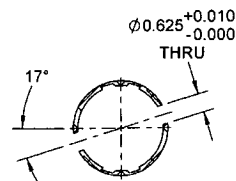
DETAIL AB
SCALE 2X



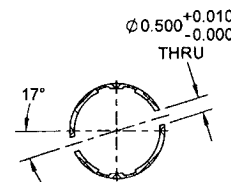
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

52955

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08-04-2016

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| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2750 | SHEET 7 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
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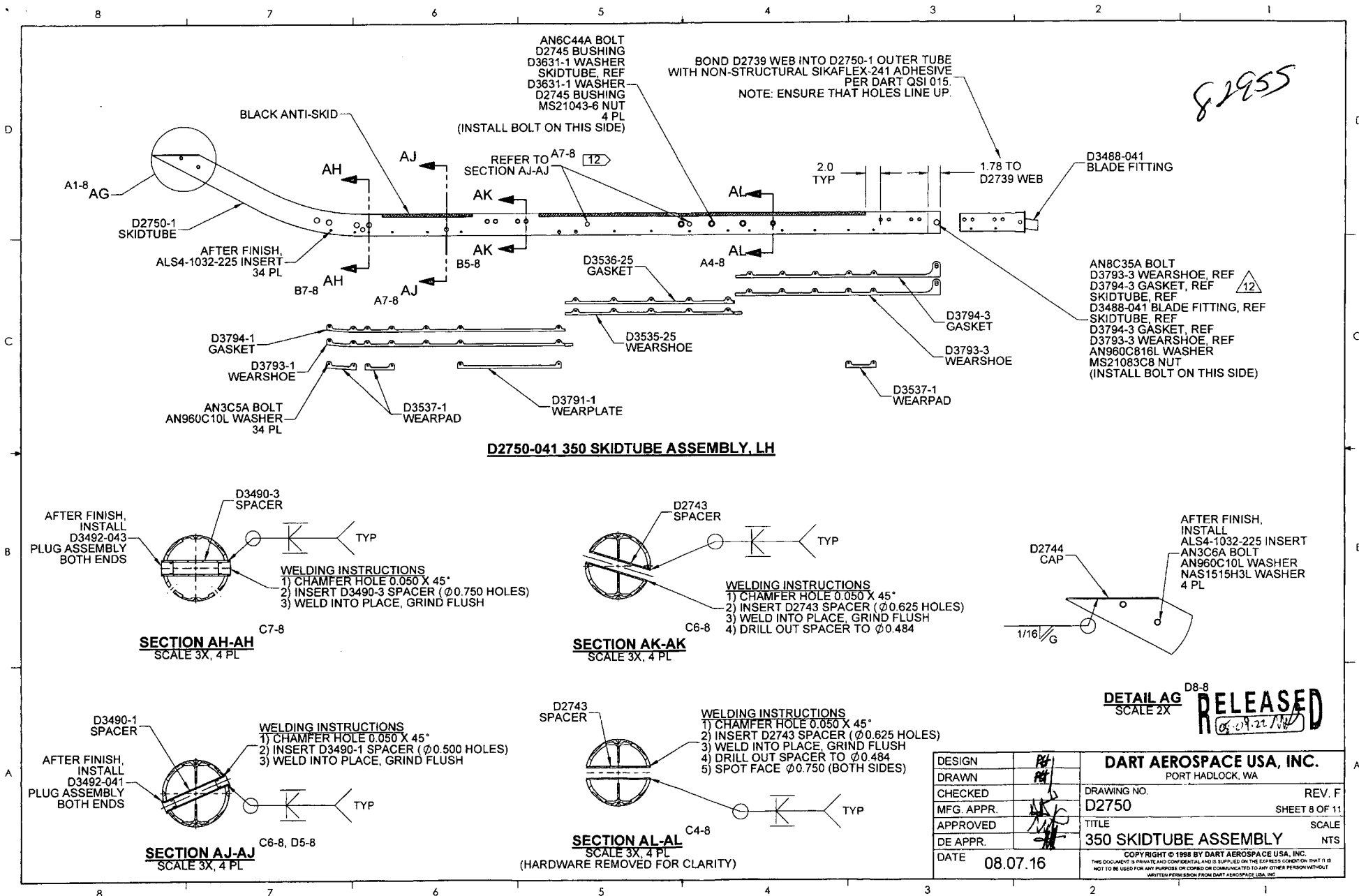
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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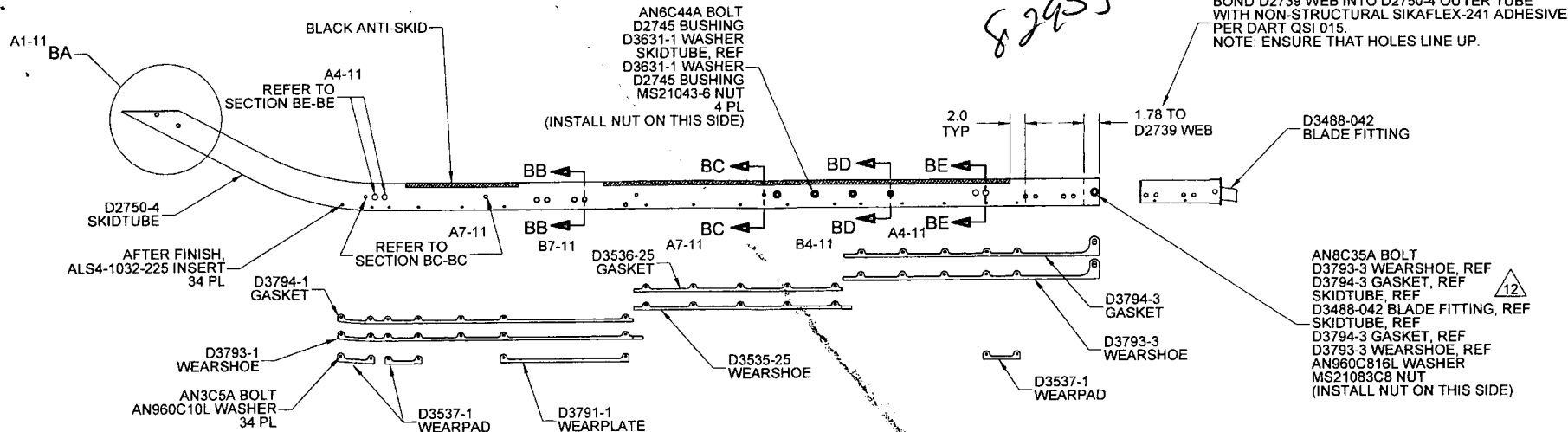
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

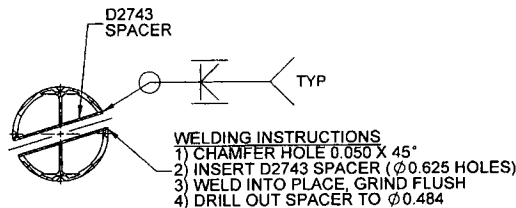
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

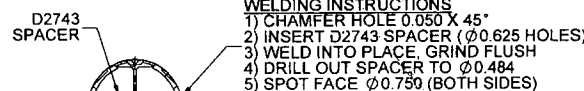
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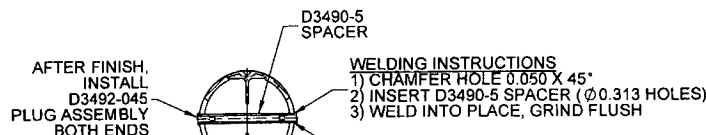
D2750-044 350 SKIDTUBE ASSEMBLY, RH



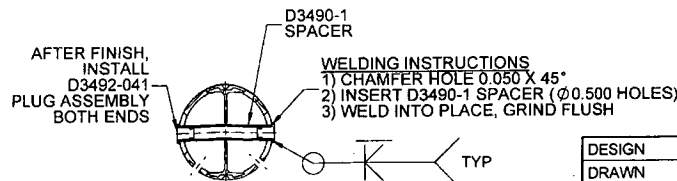
SECTION BB-BB SCALE 3X, 4 PL



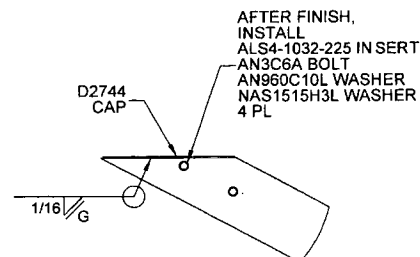
SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC SCALE 3X, 4 PL



SECTION BE-BE SCALE 3X, 4 PL



DETAIL BA SCALE 2X

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|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|
| DESIGN | ME | DART AEROSPACE USA, INC. | |
| DRAWN | ME | PORT HADLOCK, WA | |
| CHECKED | ME | DRAWING NO. | REV. F |
| MFG. APPR. | ME | D2750 | SHEET 11 OF 11 |
| APPROVED | ME | TITLE | SCALE |
| DE APPR. | ME | 350 SKIDTUBE ASSEMBLY | NTS |
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08-07-22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

NO. 293

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 82796
Part number: A350-636-014
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Reed Date of Test Coupon 12-05-01
Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

